

Work Order ID 50128

July 8, 2009 11:50:01 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D2221

Rev H

100



Large Fab

Large Fab

Memo
1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221-2-
remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221-3- tack weld mesh on basket as per dwg D2221 A/R ER316
S.S. Rod Batch: 1109213

110



QC9- Inspect visual per QSI004- Fusion Welds

QC

Quality Control

120



QC6- Inspect dimensions to drawing

QC

Quality Control

0.00

0.00

0.00

0.00

opl 09-07-14

=7 S 09-07-14

PD 09-07-13
SP 09-07-13

(1) *6*

Work Order ID 50128



July 8, 2009 11:50:01 AM

Page 2

Item ID: D2221

Accept



Setup

Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/24/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BF 09-07-16

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/21 *J*

h 09.07.17

Picklist Print

July 8, 2009 11:50:00 AM

Page 1

Work Order ID: 50128



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured		No		100	Each	14.0000	1.0000			

Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	14
48101	1
48318	5
48427	8

1x

8/09/09

D2221-5RevH



Manufactured No

100 Each 4.0000 2.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	4
48390	4

2x

8/09/09

D2221-7RevH



Manufactured No

100 Each 6.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	6
48201	2
48450	4

1x

8/09/09

Picklist Print

July 8, 2009 11:50:00 AM

Page 2

Work Order ID: 50128



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC



Manufactured

No

100

Each

15.0000

2.0000



Basket Hinge

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

15

47263

3

48443

12

D2235-1RevB1



Manufactured

No

100

Each

7.0000

2.0000



Basket Rib

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

7

48665

7

D2581RevA1



Manufactured

No

100

Each

35.0000

2.0000



Mounting Bracket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

35

46086

2

48428

33

Picklist Print

July 8, 2009 11:50:00 AM

Page 3

Work Order ID: 50128



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA 		Manufactured	No			100	Each	22.0000	2.0000			

Shim

Warehouse

Location

Main Warehouse

ST	22
46767	1
47074	9
50023	12

D3825-041RevA



Manufactured

No

100

Each

8.0000 2.0000



Rib Assembly (Basket End)

Warehouse

Location

Main Warehouse

ST	8
48430	2
48668	6

D3826-041RevB



Manufactured

No

100

Each

6.0000 2.0000



Rib / Gusset Assembly

Warehouse

Location

Main Warehouse

ST	6
48644	6

Picklist Print

July 8, 2009 11:50:00 AM

Page 4

Work Order ID: 50128



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured		No		100	Each	7.0000	1.0000			

Rib Assembly (Inboard)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		Loc Qty	Loc Code
								<u>Location</u>			
D3832-1RevA		Manufactured		No		100	Each	2.0000	1.0000		
Mesh (Base)											

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		Loc Qty	Loc Code
								<u>Location</u>			
D3833-1RevA		Manufactured		No		100	Each	7.0000	2.0000		
Mesh (Base End Face)											

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		Loc Qty	Loc Code
								<u>Location</u>			

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

W/ 5/28

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

RE 08/11/18

NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 42.00 lbs APPROX
 8) MASK ALL HOLES PRIOR TO POWDER COATING

REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED SECTION D (ZN B7-4); ADDED SECTION E (ZN A6-4); ADDED SECTION F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 0.0000 FOR D2221-1/5-7 (ZN D8-3 AND 1/5-7); D2221-1/5-7 ADDED; D2221-1/5-7, D3826-041 REPLACES D2235-1; D2235-1, D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.

H MB 08.09.18

G AJS 08.06.16

F PH 05.06.07

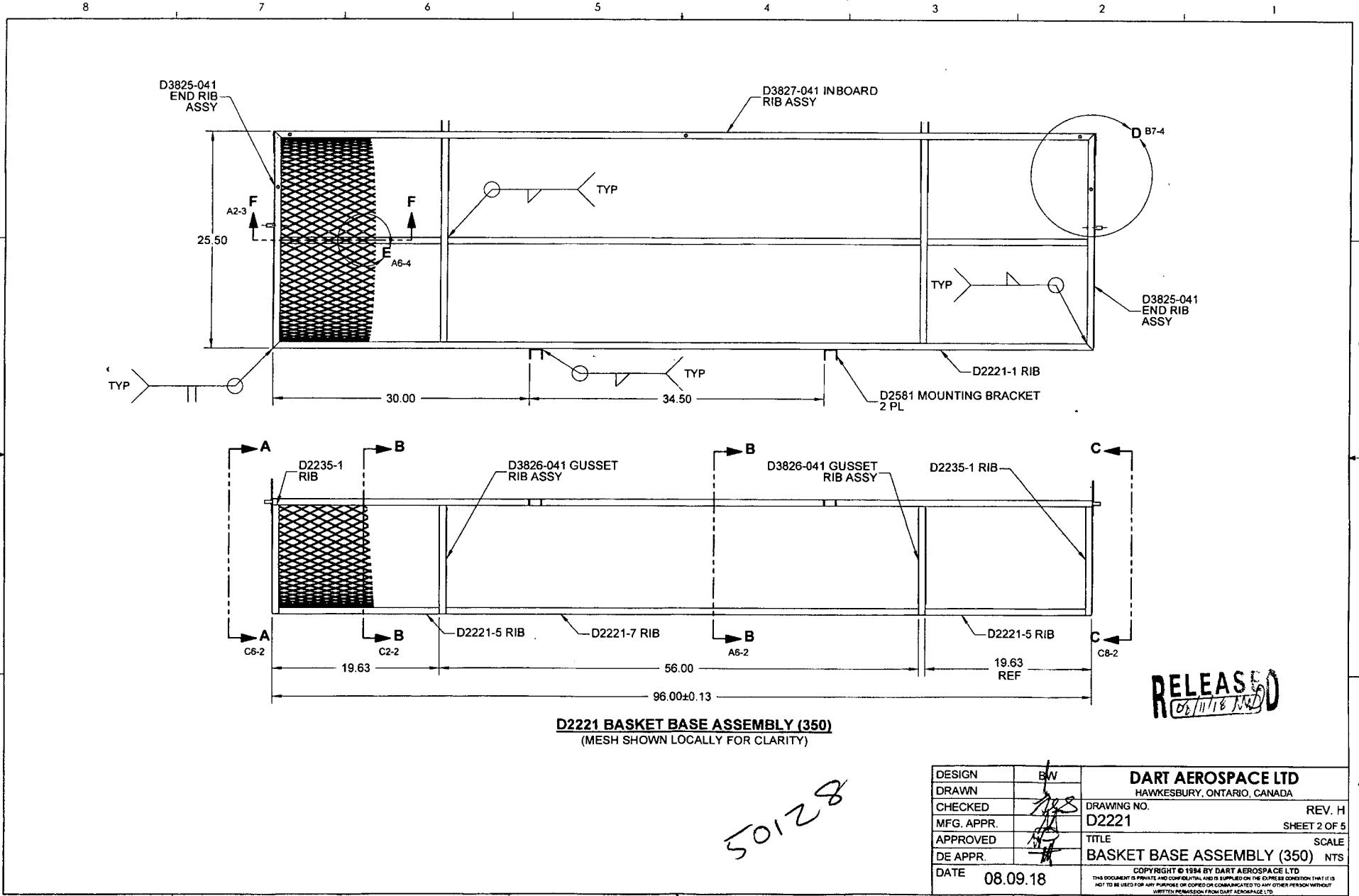
E CP 01.04.19

D BW 96.06.21

C KH 95.11.21

REV. **DESCRIPTION** **BY** **DATE**

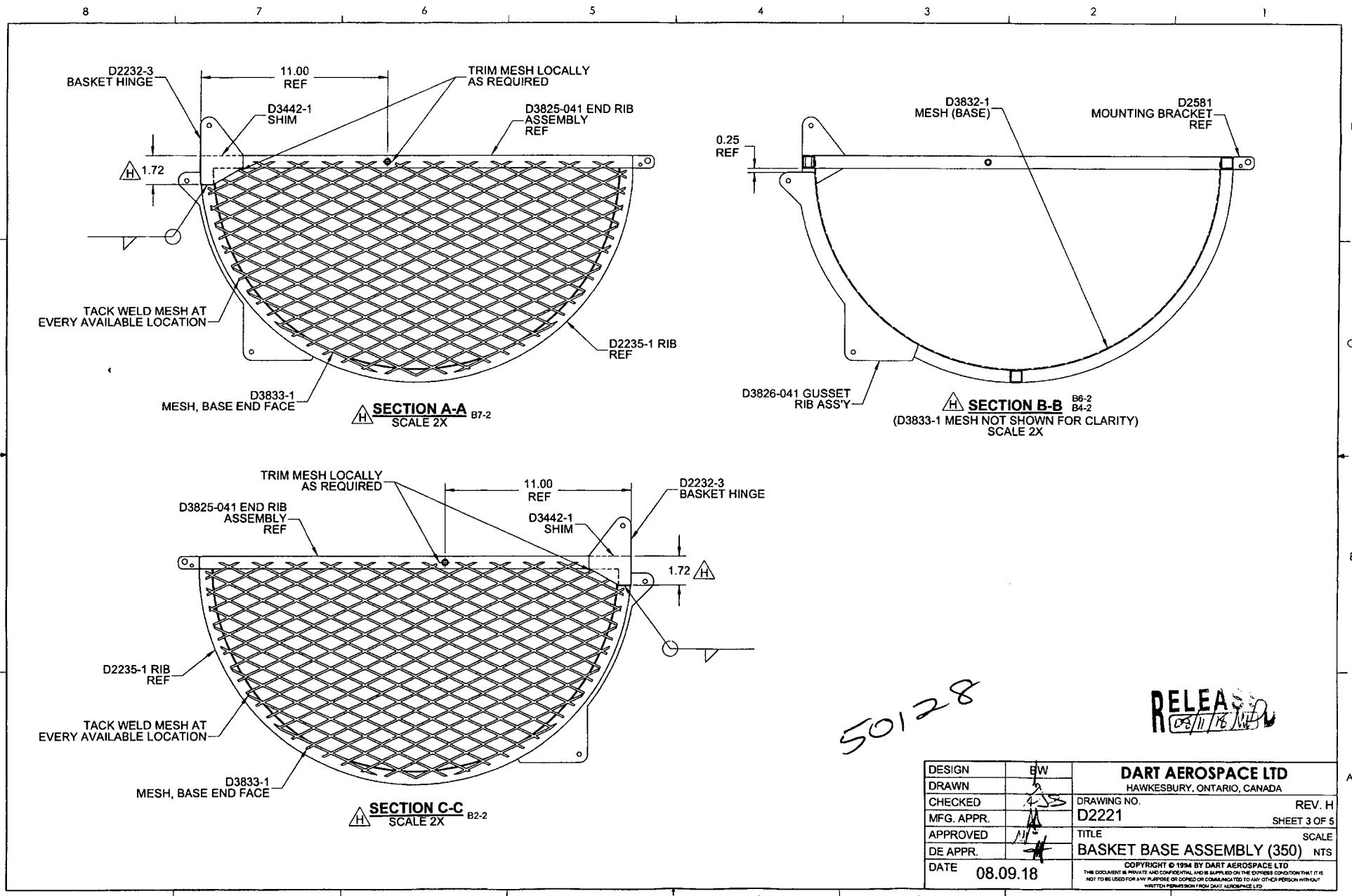
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO. REV. H	
MFG. APPR.	<i>✓</i>	D2221 SHEET 1 OF 5	
APPROVED	<i>✓</i>	TITLE SCALE	
DE APPR.	<i>✓</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

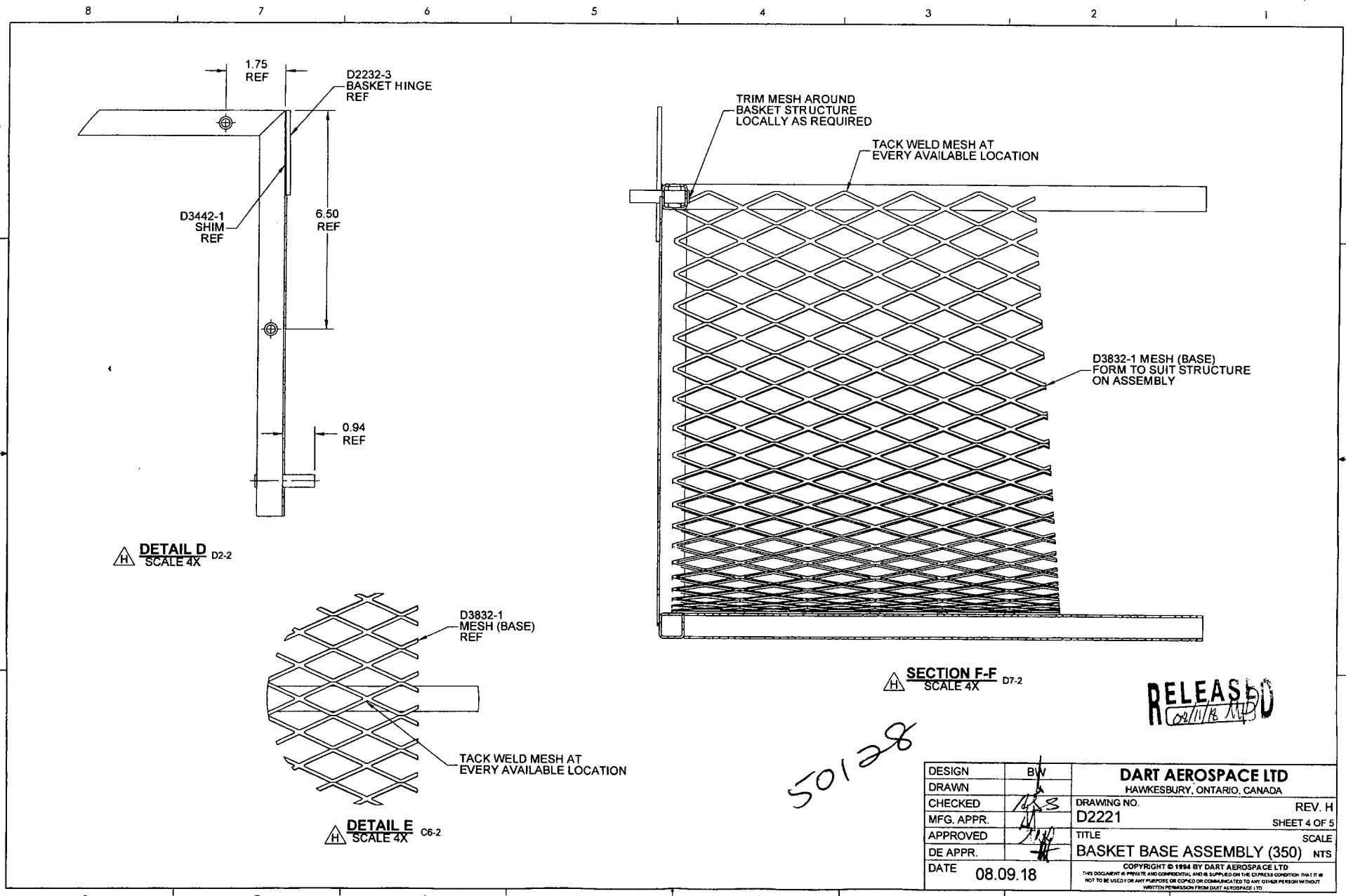


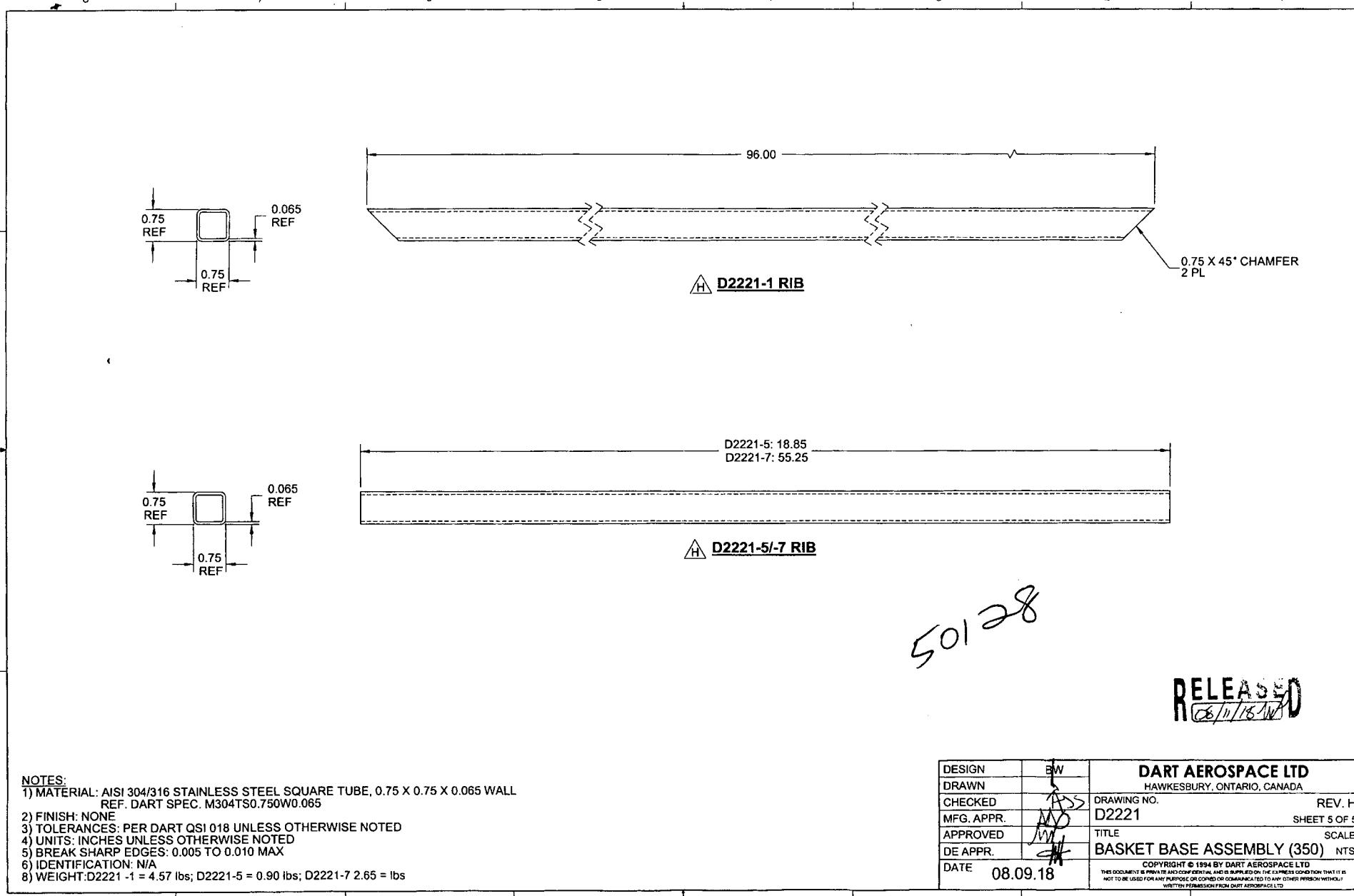
50128

DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2221
APPROVED		REV. H
DE APPR.		SHEET 2 OF 5
DATE	08.09.18	TITLE
		BASKET BASE ASSEMBLY (350) NTS

COPYRIGHT © 1994 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD







DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>ASS</i>	DRAWING NO. REV. H
MFG. APPR.	<i>MD</i>	D2221 SHEET 5 OF 5
APPROVED	<i>WV</i>	TITLE SCALE
DE APPR.	<i>WV</i>	BASKET BASE ASSEMBLY (350) NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS A PRIVATE DRAWING OF DART AEROSPACE LTD. THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.